

Work Order ID 160316

Tuesday, April 25, 2017 2:19:10 PM

160316

Page 1

Item ID: D3805-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Run-on Landing Wearplate Fwd
Start Date: 4/26/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 5/5/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULED
Approvals: Process Plan: DAS 21 9-89 Date: **APR 25 2017** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3805	D

110

0.00

110

Large Fab

Memo

3.84

Large Fab

1- Weld D3806-041 to wearplate as per dwg D3805
304 S.S. Welding Rod
BATCH #: 136585

2- Transfer drill holes in bar

6DY/Q.L 17-05-05

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

617-05-05 PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

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130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.12				<u>6</u>	<u>17-05-08</u>	<u>1</u>	
140 *140* Small Fab Small Fab	QC5- Inspect part completeness to step on W/O Memo APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 10 ON DWG)	0.00 0.72				<u>6</u>			DAS 02 9-89 1705-17
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.12				<u>6</u>			DAS 38 9-89 MAY 18 2017

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		OTHER : ☐							

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location:	0.00							
160									
Packaging	Memo	0.06							
Packaging	LOCATION : FP002								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.60							
Quality Control									

Handwritten notes:
- "sold" in blue ink next to operation 160.
- "5m/s 17/5/18" in blue ink next to operation 170.
- "DAS 21 9-89" in blue ink next to operation 170.
- "MAY 18 2017" in blue ink next to operation 170.

MAY 18 2017**DAS
21
9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐									

Picklist Print

Tuesday, April 25, 2017 2:19:22 PM

Page 1

Work Order ID: 160316

160316

Parent Item: D3805-041

D3805-041

Parent Item Name: Run-on Landing Wearplate Fwd

Start Date: 4/26/2017

Required Date: 5/5/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:EC IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC IPP REV:D 14.04.22 DWG REV.C DD VERF:JLM IPP REV:E 16.04.01 DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3805-1

Manufactured

No

110

Each

4.0000

1

6

D3805-1

Plate

**

DYK 17/05/04

Location

Loc Qty

Loc Code

WA001

4

160316 2x

149600

1

154009

1

154104

2

1
1
2

D3806-041

Manufactured

No

110

Each

2.0000

1

6

D3806-041

Wearbar Weldment

**

DYK 17/05/04

Location

Loc Qty

Loc Code

WA001

2

153071

2

160316

2
4

DQA: _____ Date: _____



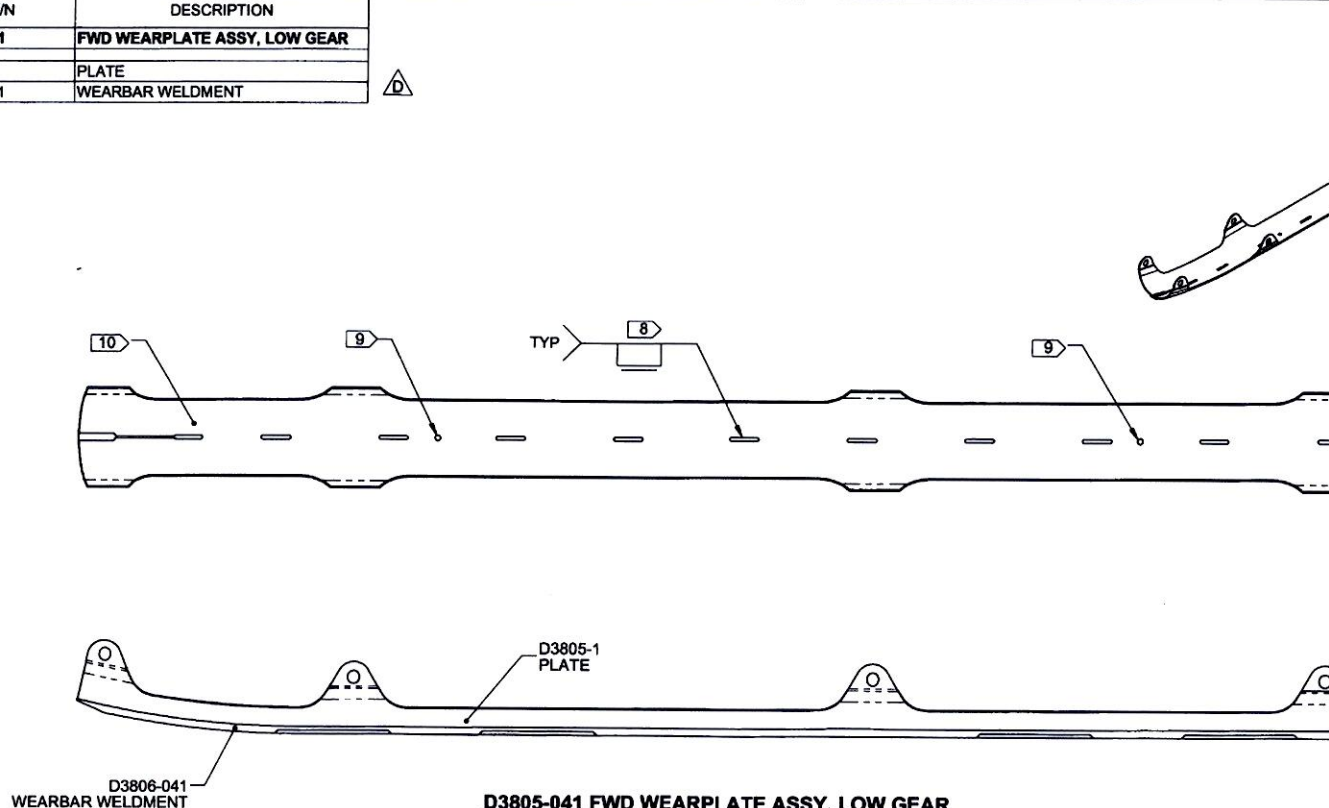
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Misidentified ☐	Past Due ☐																																																																

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3805-041	FWD WEARPLATE ASSY, LOW GEAR
1	1	D3805-1	PLATE
2	1	D3806-041	WEARBAR WELDMENT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160316 *mcj*
1701-25

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.65 lbs
- 8) WELDING: PER QSI 004
- 9) AFTER WELDING, TRANSFER DRILL $\varnothing 0.19$ THRU THE WEARBAR FROM THE PLATE
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

D	HARDCOAT MOVED TO D3806. REASON: ROBOTIC PROCESS. GENERAL UPDATE TO CURRENT STANDARDS. TOLERANCES FOR -1F, -3F, -5F & 7F UPDATED.	AJS	16.02.25
C	REMOVE ITEMS 19, 20, 21, 22 AND 32 FROM BOM (ZN C4-1) REVISE NOTE 11, SHEETS 2&3 (ZN A8-2, B2-2, B6-2, A8-3, B2-3, B6-3)	DB	13.10.04
B	REVISED D3805-1F/-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC. EUGENE, OR DRAWING NO. D3805 TITLE WEARPLATE ASSY DATE 16.02.25	
DRAWN	AJS		
CHECKED	ML		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS	REV. D SHEET 1 OF 9 SCALE NTS	
DATE	16.02.25	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2016-03-31
ENR-553

APPROVED

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Tribal Knowledge ☐	Rushing ☐																																																																						
LOA ☐	Product Improvement ☐																																																																						
Substation ☐	Process Improvement ☐																																																																						
Past Expiry Date ☐	Manufacturing Process ☐																																																																						
Misidentified ☐	Past Due ☐																																																																						
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																				
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																				
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																				
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																				
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																				
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																				
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																				
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
		OTHER : _____																																																																					